

Work Order ID 56194

February 12, 2010 10:38:31 AM



Page 1

Item ID: D3838-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 2/12/10 Start Qty: 2.00



Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

M

Date: *10-2-12*

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3838

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3838-2 and D3838-3 rib as per dwg D3838

2- remove identification markings

3- deburr

SAN 10-02-23

4- weld D3838-2 to D3838-3 and drill hole (3/16") using DT9437 jig and open to finish size as per dwg D3838

A/R ER316 S.S. Rod Batch: *M108160*

5- c'sink hole as per dwg

6- grind weld flush where indicated on dwg D3838

7- weld D3759-1 bushing as per dwg D3838

A/R ER316 S.S. Rod Batch: *M108160*

8- grind bushing weld flush as per dwg dwg D3838

9- deburr hole if necessary

(2)

EL 10-2-23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Revision ID:

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Start Date: 2/12/10 Start Qty: 2.00

Required Date: 2/18/10 Req'd Qty: 2.00




Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00	8/10/2025			(12)			
120  QC Quality Control	QC9- Inspect visual per QS1004- Fusion Welds Memo	0.00 0.00				(2)		6/10.02.24	
130  Packaging Packaging	Identify as per dwg & Stock Location: <u>WA</u> Memo	0.00 0.00	SAD 10-03-01			(2)			

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Page 3

Item ID: D3838-042

Accept

Setup Start

Revision ID:

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Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 2/12/10 Start Qty: 2.00

Cust Item ID:

Required Date: 2/18/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start

Approvals: Process Plan: Date: Tooling: Date:

Stop

QC: Date: SPC (Y/N): Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/03/03 *[Signature]*
ME
10-3-01

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

February 12, 2010 10:38:34 AM

Page 1

Work Order ID: 56194



Parent Item: D3838-042



Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 2/12/10

Required Date: 2/18/10

Comments: IPP Rev:A 08-12-01 new issue DD verified by:EC

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D3759-1		Manufactured	No			100	Each	36.0000	2.0000			
---------	--	--------------	----	--	--	-----	------	---------	--------	--	--	--



Bushing

EL 10-2-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

WA 36

53442 2

54072 9

55789 25

M304TS0.750W.065 Purchased No



304 SQ Tube .75x.75x.065W

100 f 473.1552 2.1720



SAD 10-02-23

Warehouse Loc Qty Loc Code

Location

Main Warehouse

MAT 473.1552242

113082 0.00419

113245 0.00038421

113683 16.30855

113836 76.8421

113956 380

Main Warehouse

WA 0.0000047

112398 0.0000047

~~2.1720~~ 2.1720

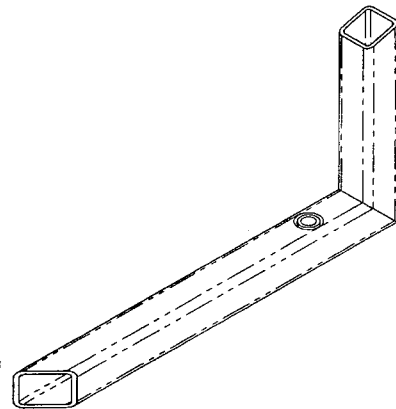
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

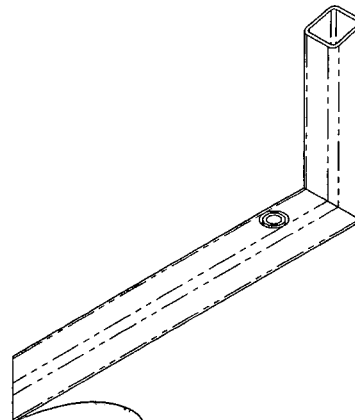
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NOTE: Date & initial all entries



D3838-041 RIB ASSY (BASKET LID, LH)



D3838-042 RIB ASSY (BASKET LID, RH)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3838-041	RIB ASSY (BASKET LID, LH)
2		X	D3838-042	RIB ASSY (BASKET LID, RH)
3	1	1	D3759-1	BUSHING
4	1		D3838-1	RIB
5		1	D3838-2	RIB
6	1	1	D3838-3	RIB

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36194
B-10-2-12

RELEASED
08/11/12

A	NEW ISSUE		MB	08.10.08
REV.		DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3838	SHEET 1 OF 3
APPROVED			TITLE	SCALE
DE APPR.			RIB ASSY (BASKET LID)	NTS
DATE	08.10.08			
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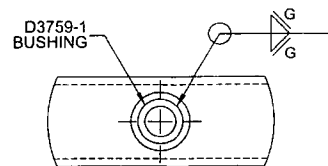
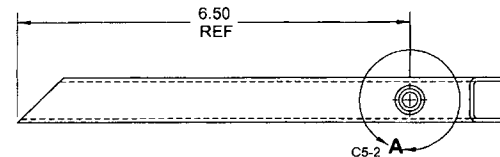
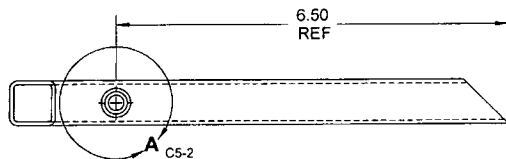
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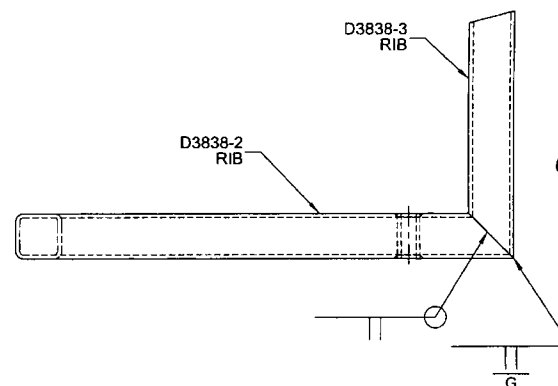
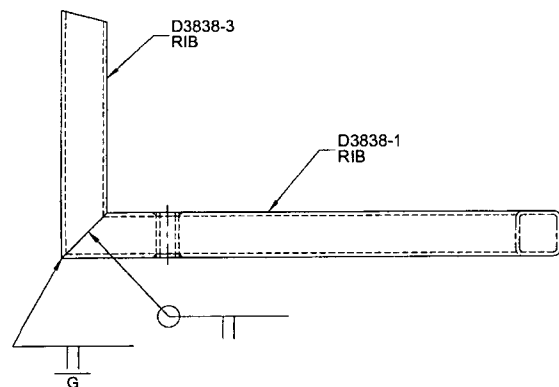
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NOTE: Date & initial all entries



DETAIL A
D2-2
D7-2 SCALE 2X



w/050194

D3838-041 RIB ASSY (BASKET LID, LH)

D3838-042 RIB ASSY (BASKET LID, RH)

RELEASED
08/11/18/14

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.			SHEET 2 OF 3
APPROVED		TITLE RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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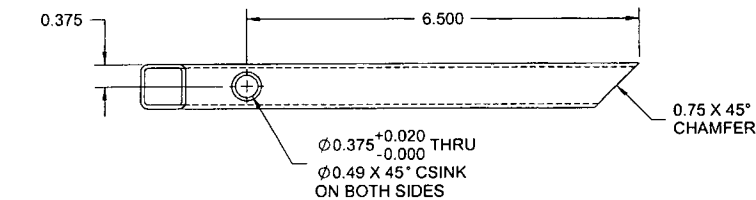
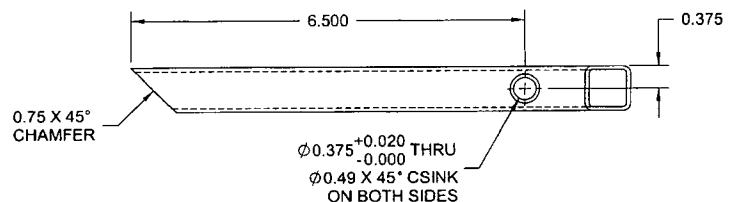
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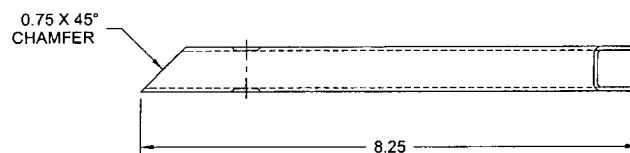
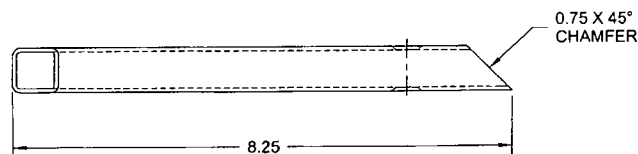
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C

C

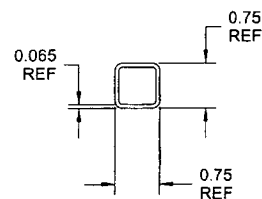
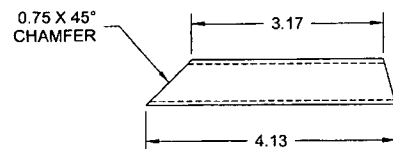


D3838-1 RIB

D3838-2 RIB

B

B



D3838-3 RIB

TYPICAL SECTION VIEW

W/O 56194

RELEASED
26/11/18 JH

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.35 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3838	REV. A
MFG. APPR.		SHEET 3 OF 3	
APPROVED		TITLE	SCALE
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8 7 6 5 4 3 2 1

A

A

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